

Date: Tuesday, 3/11/2008 7:57:23 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STRUT		
Job Number	37742					
Estimate Number	10200					
P.O. Number			Part Number	D21991		
This Issue	3/11/2008	S.O. No.	Drawing Number	D2199 REV. E1		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	E1		
Previous Run	28996		Material			
Written By			Due Date	3/25/2008	Qty:	4 Um: Each
Checked & Approved By	<i>KJ 08/03/11</i>					
Comment	Est B 02.06.10 Added finish		NG/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.6275 f(s)/Unit Total : 6.5100 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	<i>SB 08/03/17 (4)</i>
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch per Dwg. D2199 and Spec Control Dwg D2638	<i>SB 08/03/17 (4)</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>EB 08/03/18 (4)</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>S 08/03/18 (4)</i>
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	<i>M 107005 (4)</i>
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		Comment: INSPECT POWDER COAT	<i>BL 08-03-19 (4X)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 20/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D21991

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 258

1/83/19

(4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

1/83/19

Job Completion



2008/3/19

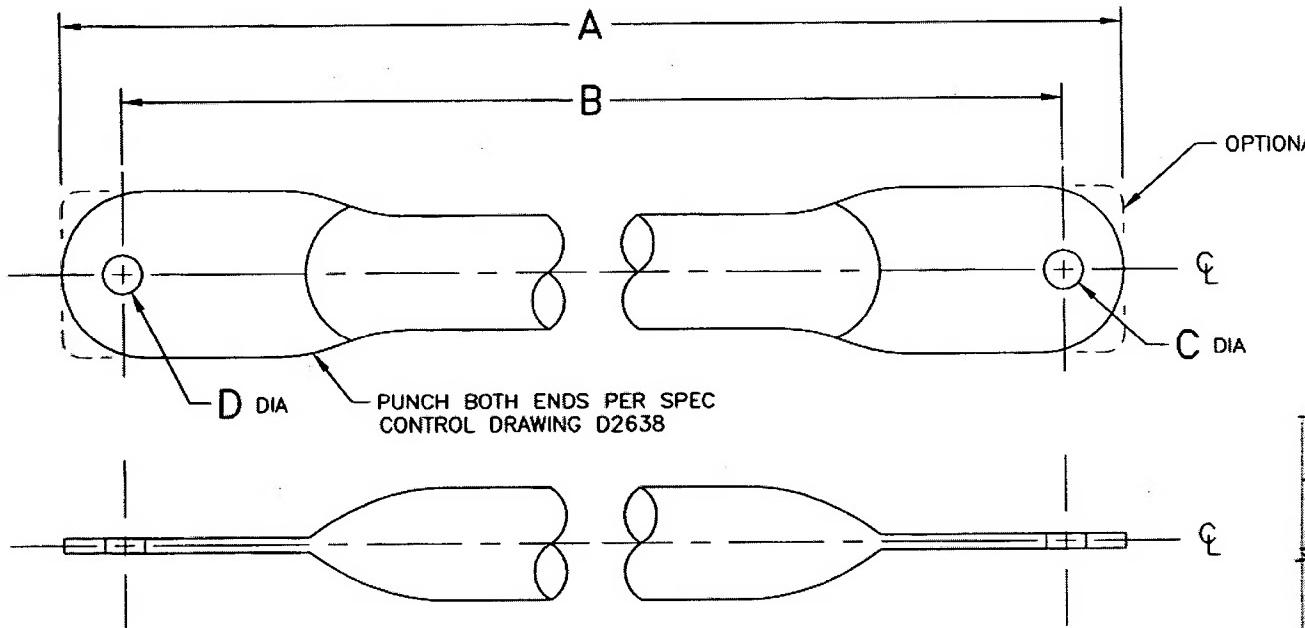
(4)

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- PUNCH BOTH ENDS PER SPEC
CONTROL DRAWING D2638

	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

3 ^E ~~ff~~ 00.10.13
6 0.10.13

NOTES:-

- OTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.750 \times 0.049$ WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3.5.2

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37742

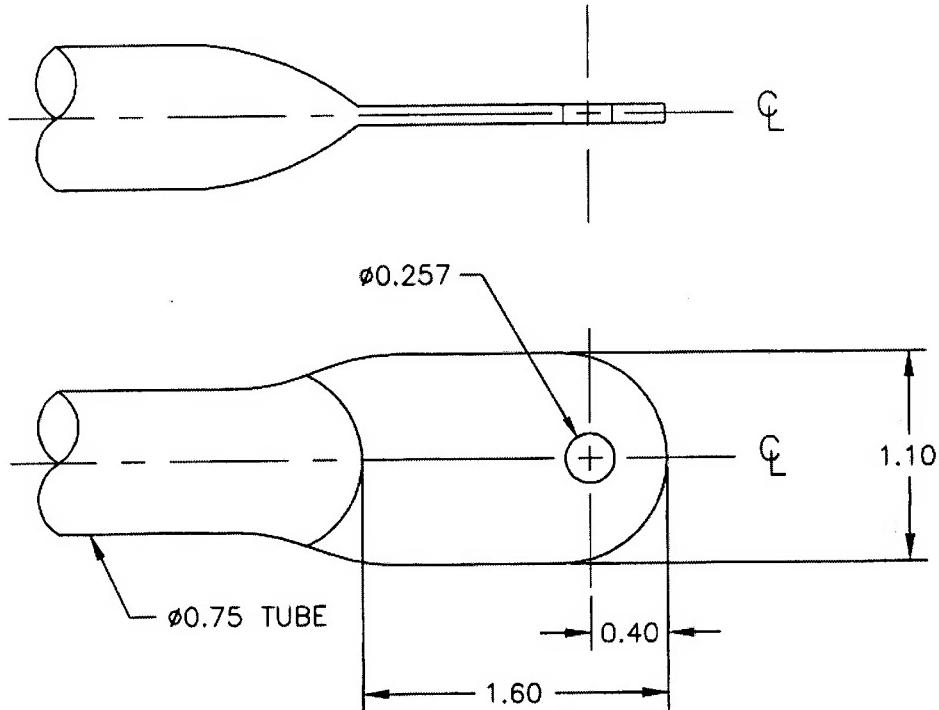
RELEASED		DART		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1	REV. E	
98.04.28		D2199			
A	1993	TITLE STRUT DETAILS	SCALE NTS		
B		ADDED -11, -13, AND -15			
C		ADDED -17 AND -19			
D		ADDED -21			
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD			
E1	02.03.22	ADD FINISH			

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DMD	APPROVED JF	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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NO. *37742*